

Work Order ID 119564

119564

Page 1

June-09-14 11:34:07 AM

Item ID: D3283-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 5/15/14 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: [Signature] Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3283	Rev E

105		0.00							
105									
Purchasing	Memo	0.00							
Purchasing	ISSUE PO 24574								
	CUT PER DRWG D3283 REV.E								

CY 14/100/12 40

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging	Memo	0.00							
Packaging									

P4711 (70)

125	QC6- Inspect dimensions to drawing	0.00							
125									
QC	Memo	0.00							
Quality Control									

39 DAS 38 9-89 14-9-24

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June-09-14 11:34:07 AM

Item ID: D3283-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 5/15/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

40 76 14-9-15

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS

9
3-89

40 9/14 14-09-15

170

Identify as per dwg & Stock Location: 46

0.00

170

Packaging

Memo

0.00

Packaging

40 DGL 14-9-16

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June-09-14 11:34:07 AM

Item ID: D3283-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 5/15/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCS 14-09-18

② 14-9-17

Picklist Print

June-09-14 11:34:06 AM

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Work Order ID: 119564

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Parent Item: D3283-1

D3283-1

Parent Item Name: Doubler

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP A04.09.28New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

503.0880

0.2361

10

M6061T6S 063

6061-T6 .063 Sheet

**

CLY/06/27

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

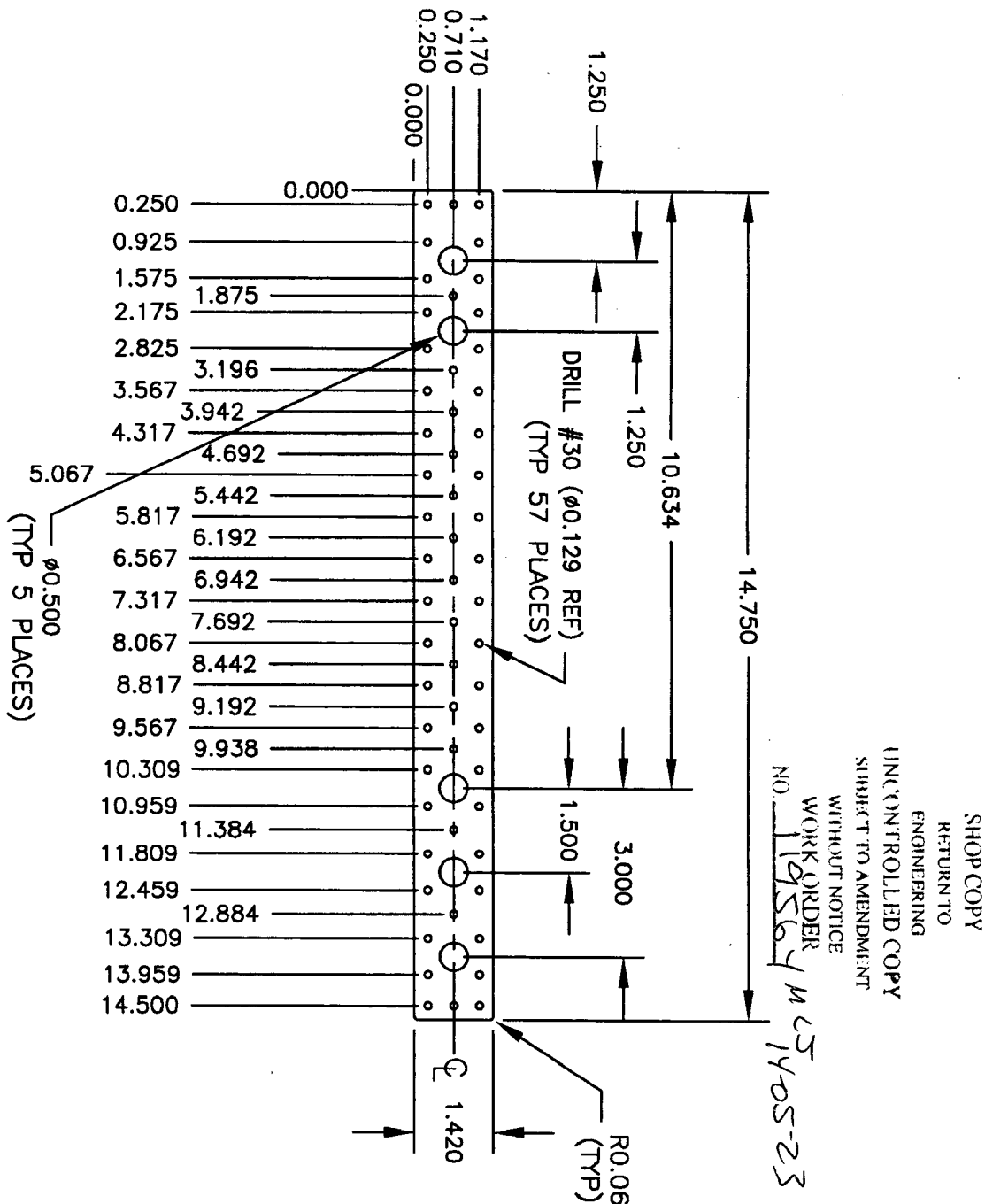
M128941

284

m129637

10

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- D3283-1 DOUBLER**
- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

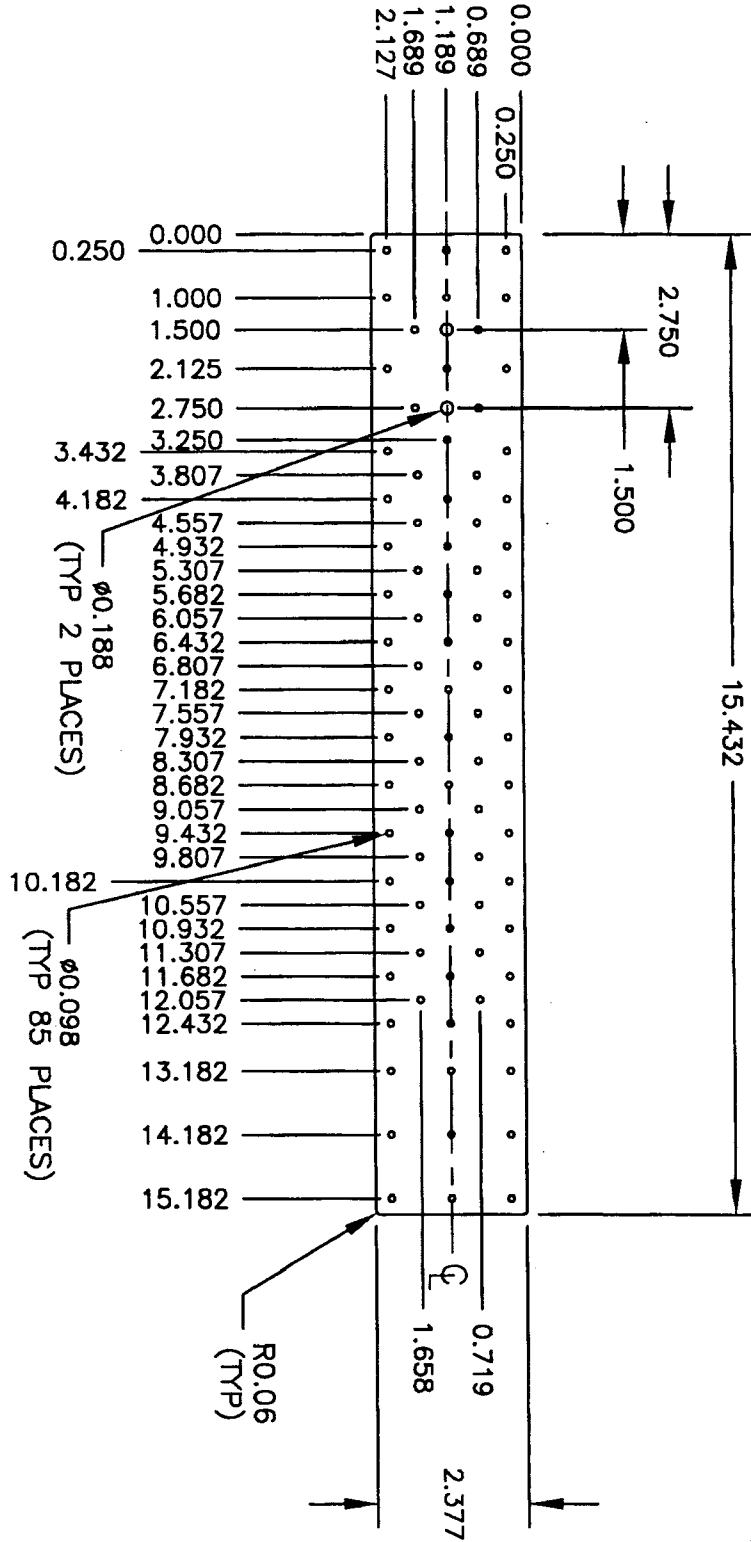
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119564 M 1405-23

RELEASED
07-08-99
PER ECN 959

DART

DESIGN	CHECKED	DATE	07.06.01	DOUBLER	SCALE	1:3
DRAWN BY	APPROVED	TITLE				
DART AEROSPACE USA, INC.	DART AEROSPACE USA, INC.	DRAWING NO.	D3283	REDESIGN	MISSING HOLE ADDED @ (7.692, 0.710)	
PORT HADLOCK, WA				CHANGE HOLE PATTERN FOR -1		
				10.882 WAS 11.502		
				NEW ISSUE		
				04.05.06		
				04.08.09		
				05.03.16		
				05.08.09		
				07.06.01		

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D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

RELEASED
07.08.99
PER ECN 959

DART

DART Aerospace USA, INC. PORT HADLOCK, WA REV. E SHEET 2 OF 2 SCALE 1:3	DRAWING NO. D3283 DATE 07.06.01 DOUBLER TITLE 07.06.01
DESIGN BY DRAWN BY APPROVED CHECKED	DATE 07.06.01

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6192
Date: 2014-07-10
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24574	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-10
Tracking No.:	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days